

ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6405G00631-3G-1	HUB ASSY
-4	1	RBW6405G00631-3G-4	PIN

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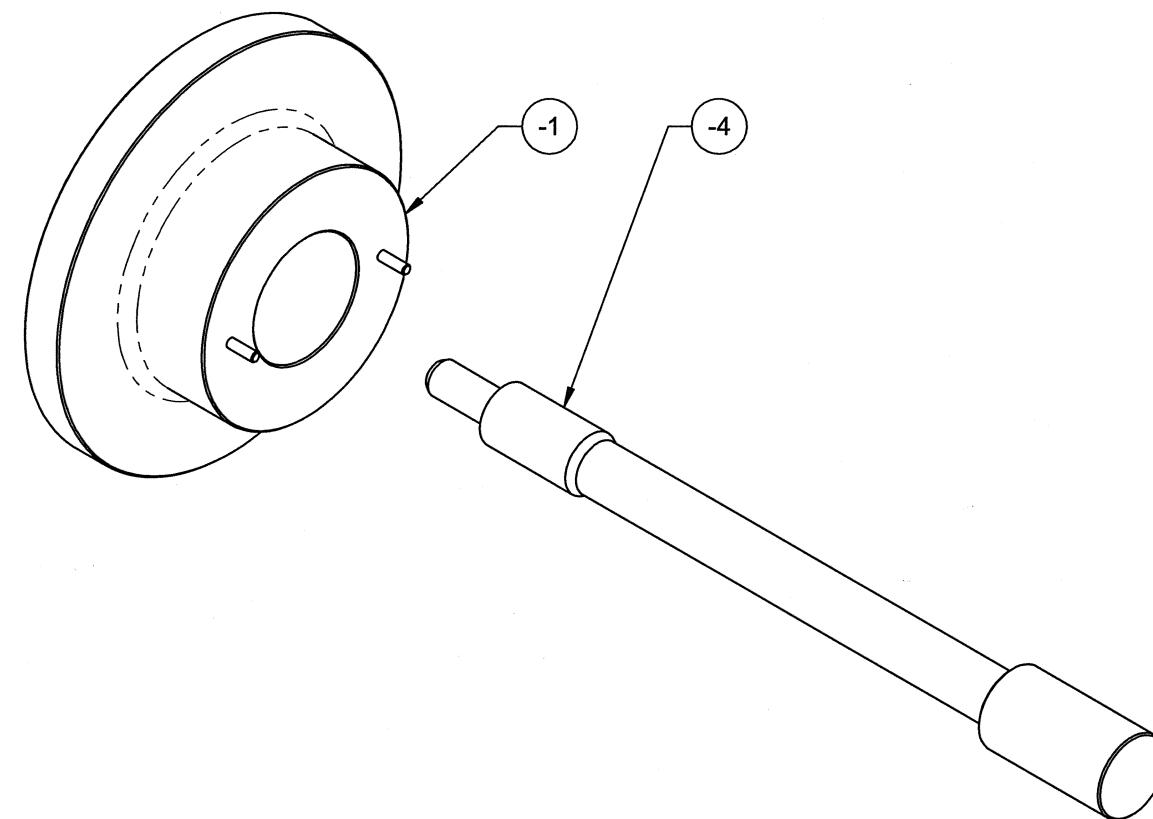
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### RBW6405G00631-3G T/R DUPLEX BEARING REMOVAL

7

#### NOTES:

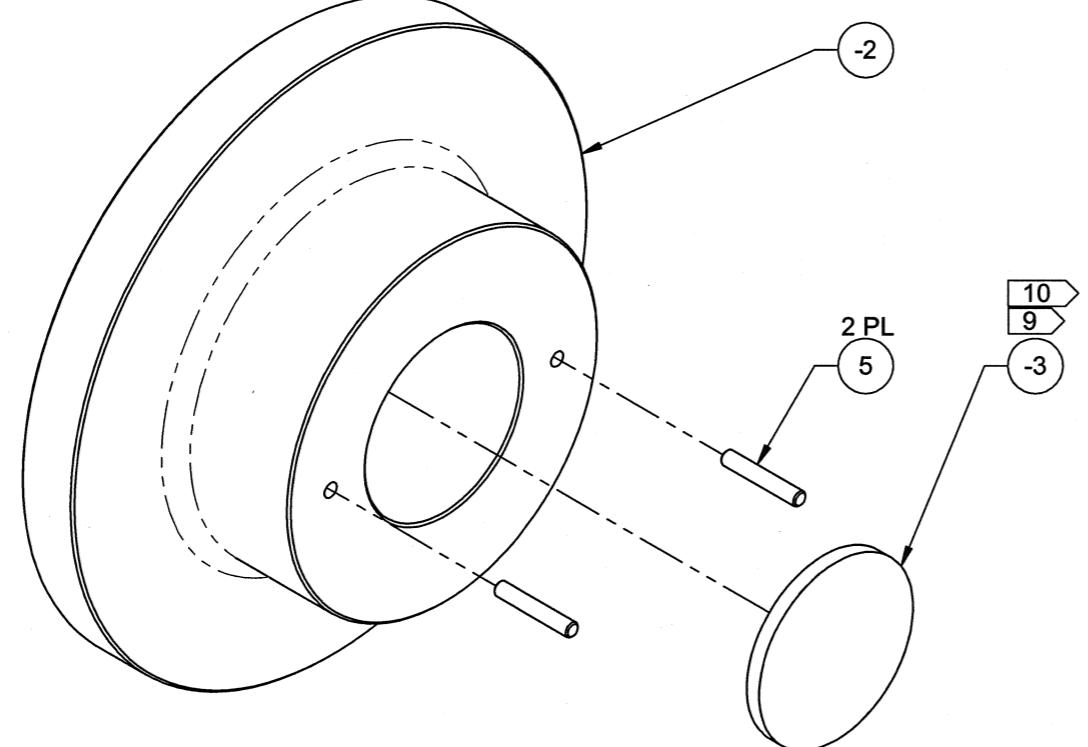
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES:  $X.X = +/- 0.1" / +/- 1^\circ$   
 $X.XX = +/- 0.01" / +/- 0.5^\circ$   
 $X.XXX = +/- 0.005" / +/- 0.1^\circ$   
 $X.XXXX = +/- 0.0005" / +/- 0.05^\circ$   
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $+/-0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

B	SEE PREVIOUS PDF FOR OLDER REV TEMPLATE UPDATED PER DART HBY STANDARDS ITEM -1 CHANGED FOR -2 ITEM -1 ASSY ADDED ITEM -3 CHANGED FOR -4 ITEM -5 McMaster#98381A511 CHANGED FOR McMaster#97395A474 ITEM -7 CHANGED FOR ITEM -3 McMaster#1374N16 ITEM -1 DIMENSION .582 CHANGED FOR .58 ITEM -2 DIMENSION 0.1875/0.1870 B.C. 3.456 DEPTH .543 CHANGED FOR 0.1875/0.1867 B.C. 3.456 +/- .001 DEPTH .54, 0.03 x 45° CMF 4 PL ADDED, R.015 ADDED, DIMENSION R.220 CHANGED FOR R.022, DIMENSION 2.362 CHANGED FOR 2.362 +0.005/-0, ENGRAVING "MADE IN USA" AND S/N REMOVED, MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE ITEM -3 DRAWING ADDED, DIMENSION 2.36 CHANGED FOR 2.34 ITEM -4 DIMENSION .668 CHANGED FOR .660, ENGRAVING REMOVED, DIMENSION 1.539 CHANGED FOR 1.54, R.008 MAX ADDED, DIMENSION R.017 CHANGED FOR R.02, MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE			VM
	REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	VM	TOOL PART #	REV. B RBW6405G00631-3G	
CHECKED	VM	TITLE	SHEET 1 OF 5 T/R DUPLEX BEARING REMOVAL	
MFG. APPR.	DP	SCALE	NTS	
APPROVED	VM	COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	3/1/2019			

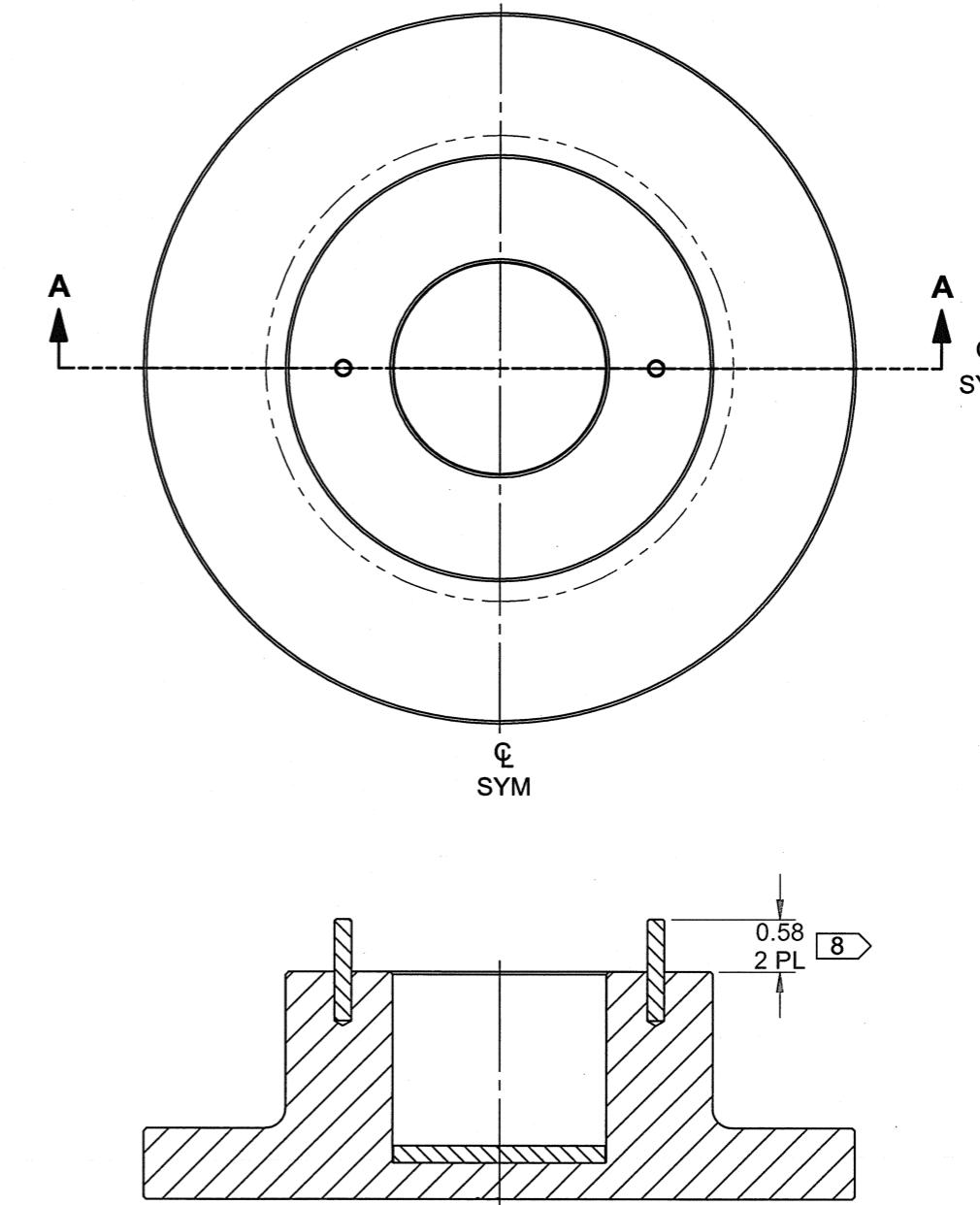
ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6405G00631-3G-2	HUB
-3	1	RBW6405G00631-3G-3	PLUG
5	2	McMaster#97395A474 OR EQUIV	SS316 DOWEL PIN 3/16" DIA. x 1-1/8" LG.

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**RBW6405G00631-3G-1 HUB ASSY**



**SECTION A-A**

**NOTES:**

1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A

4) TOLERANCES:  $X.X = \pm 0.1" / \pm 1^\circ$   
 $X.XX = \pm 0.01" / \pm 0.5^\circ$   
 $X.XXX = \pm 0.005" / \pm 0.1^\circ$   
 $X.XXXX = \pm 0.0005" / \pm 0.05^\circ$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES =  $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

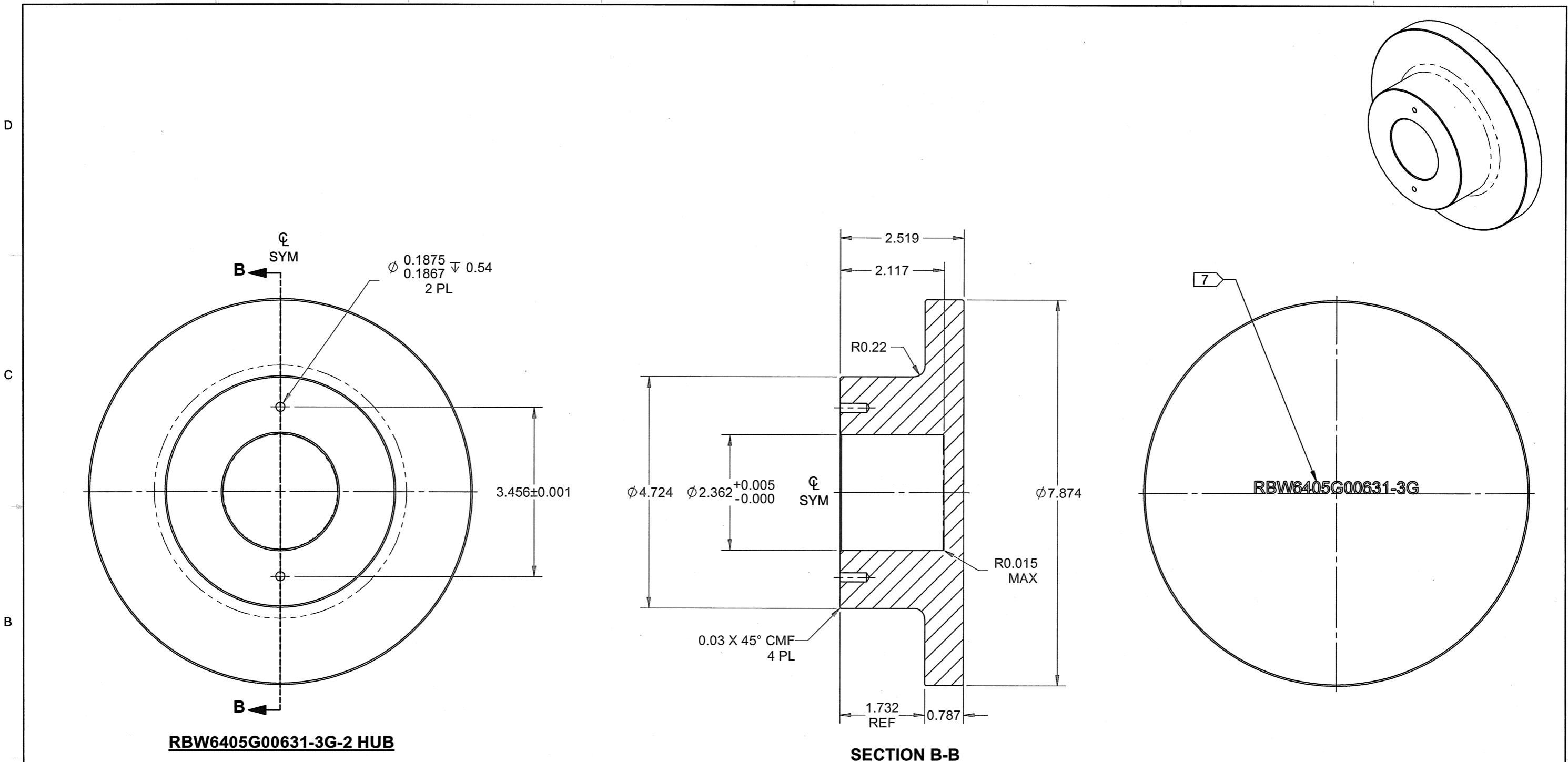
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES  
THEN PRESS FIT ITEMS 5 WITH ITEM -2, AND REMOVE EXCESS

9) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -3 AND ITEM -2 IF NECESSARY, AND REMOVE EXCESS

10) ASSEMBLE ITEM -3 ADHESIVE SIDE ON ITEM -2 AS SHOWN, AND CUT EXCESS IF NECESSARY

DESIGN	VM	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. B
MFG. APPR.	DP	RBW6405G00631-3G	SHEET 2 OF 5
APPROVED	WY	TITLE T/R DUPLEX BEARING REMOVAL NTS	
DATE 3/1/2019		SCALE	

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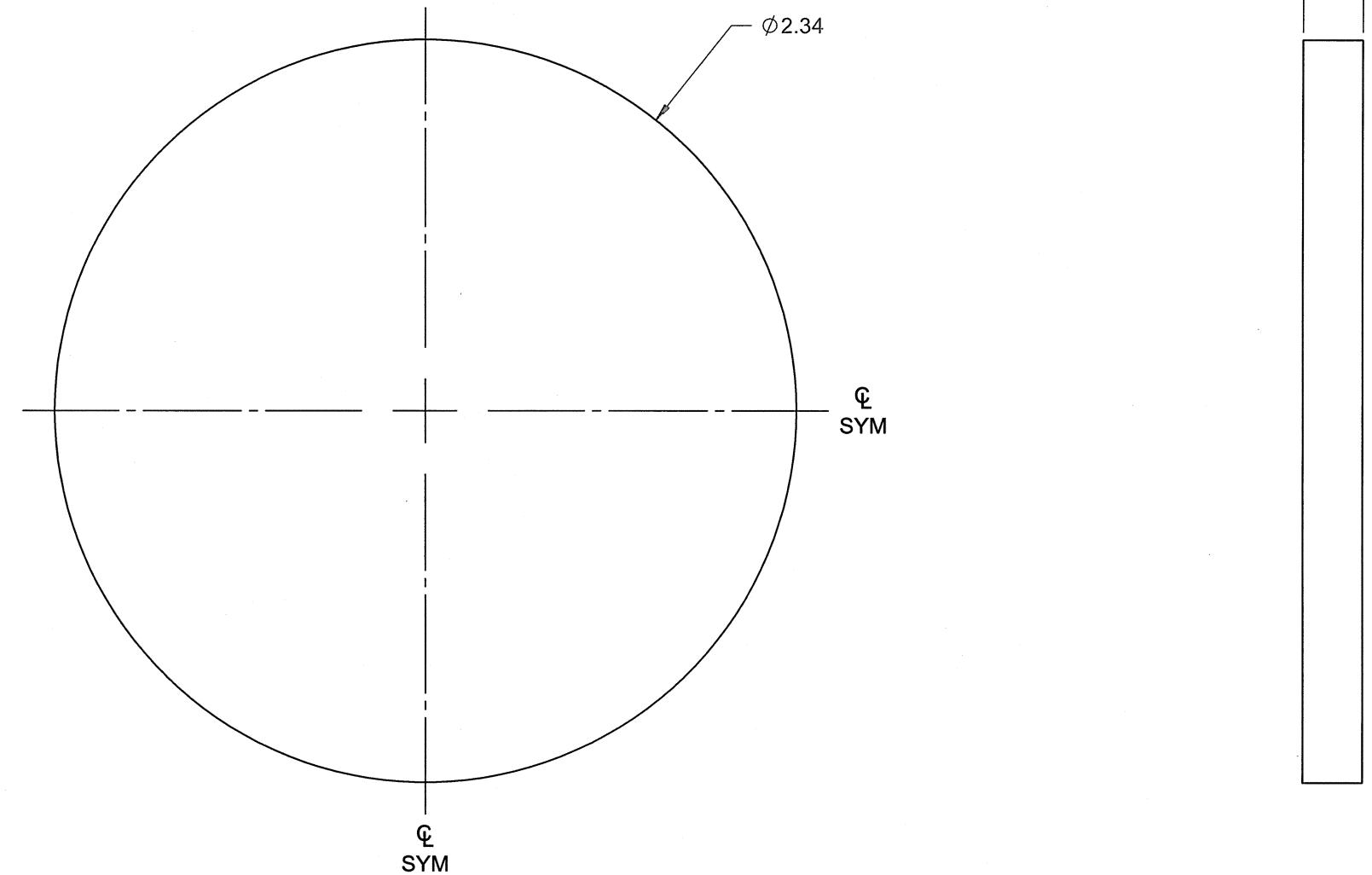
## NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	REV. B	
MFG. APPR.	DP	TOOL PART #	
APPROVED	<i>[Signature]</i>	RBW6405G00631-3G	
DATE 2019-09-11		SHEET 3 OF 5	
TITLE T/R DUPLEX BEARING REMOVAL NTS			
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A A



**RBW6405G00631-3G-3 PLUG**

**NOTES:**

- 1) MATERIAL: McMaster#1374N16 OR EQUIV (MULTIPURPOSE NEOPRENE RUBBER SHEET ADHESIVE BACK 3/16" THK. 50A DURO)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A

DESIGN	VM	<b>DART AEROSPACE LTD</b>	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM		
MFG. APPR.	DP	TOOL PART #	
APPROVED	V	RBW6405G00631-3G	
DATE 3/1/2019		REV. B	
TITLE T/R DUPLEX BEARING REMOVAL		SHEET 4 OF 5	NTS
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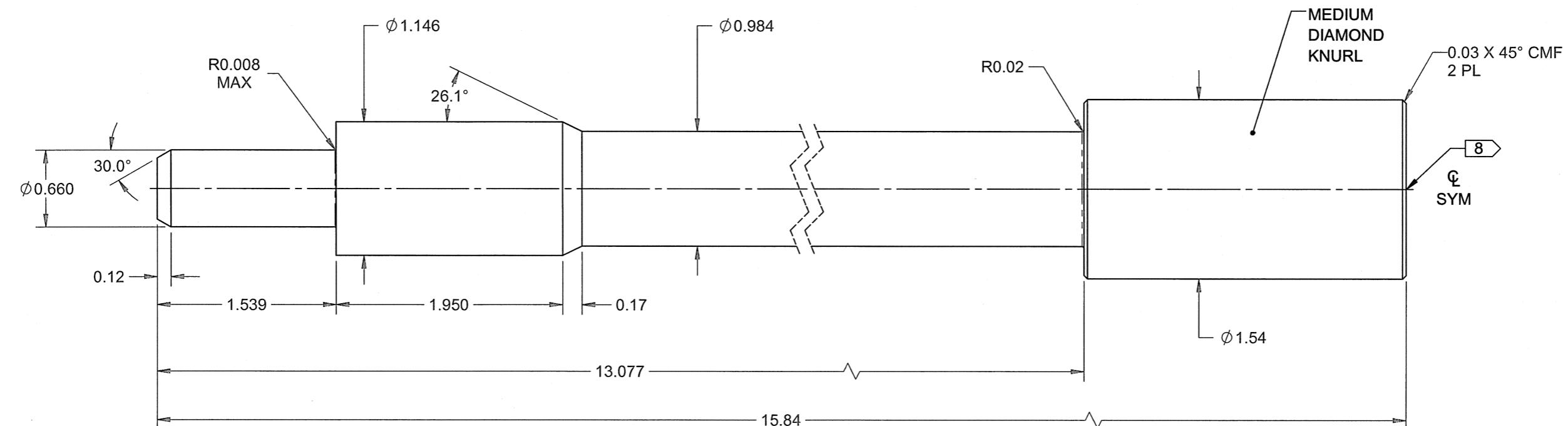
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RBW6405G00631-3G-4 PIN

## NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
 X.XX = +/- 0.01" / +/- 0.5°  
 X.XXX = +/- 0.005" / +/- 0.1°  
 X.XXXX = +/- 0.0005" / +/- 0.05°  
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD			
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA			
CHECKED	VM				
MFG. APPR.	DP				
APPROVED	VM				
TOOL PART #		REV. B			
RBW6405G00631-3G		SHEET 5 OF 5			
TITLE		SCALE			
T/R DUPLEX BEARING REMOVAL		NTS			
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DATE 3/1/2019